

Monday, 22/12/2008 8:31:55 AM
Linda Lacelle

BLUE

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY 206L/407 GHW LUG
Job Number	: 44217		
Estimate Number	: 10318		
P.O. Number	:	Part Number	: D2659
This Issue	: 22/12/2008 S.O. No. :	Drawing Number	: D2659 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 43885	Material	:
Written By	:	Due Date	: 29/12/2008 Qty: 16 Um: Each
Checked & Approved By	:		
Comment	: Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2657	Lug	
<p>Stop computer!</p>			

Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Lug 6XB34076A, 10 X 35662

EL 8-12-22 X16

2.0	D2658	Lug Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Lug Assembly B43885B

EL 8-12-22 X16

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8208
A/R Steel Rod M10835D

EL 8-12-22 X16

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

6.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: -PRIME GREY
-SPRAY PAINT DELFLEET BLUE
-CLEAR DELFLEET

RT 08-12-22

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 44217

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC14

INSPECT SPRAY PAINT



ml 08 12 23



(16)

Comment: INSPECT SPRAY PAINT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



16x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

8/12/23

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

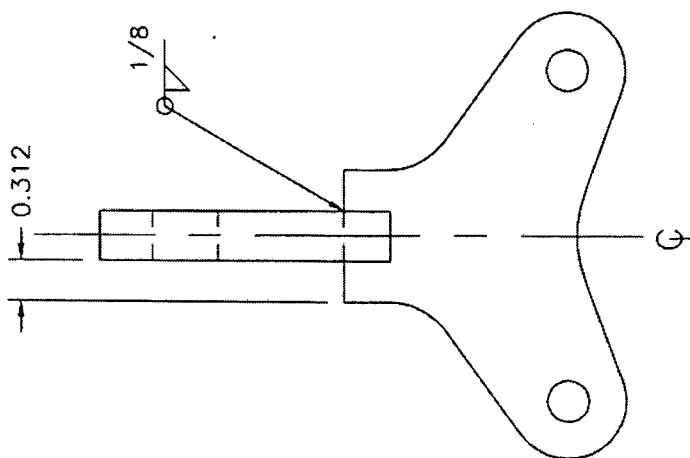
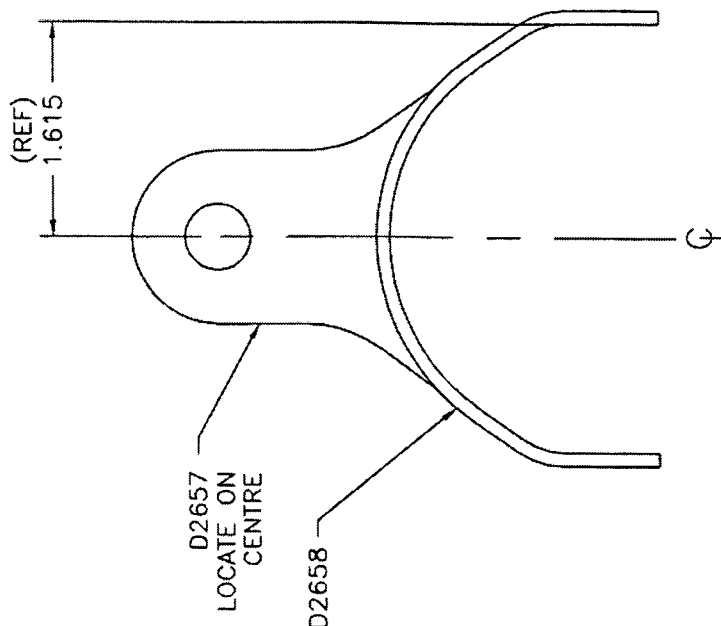
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>S</i>	APPROVED <i>U</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 PS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

W/O
4/24/7